












Date: Wednesday, 13/02/2008 11:42:59 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 37397	Part Number	: D36631
Estimate Number	: 13178	Drawing Number	: D3663 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 13/02/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : MACHINED PARTS	Due Date	: 15/02/2008
Previous Run	:	Qty:	20
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 08-02-13 DD verified by:		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0750	303 Round Bar .75"	
			
Comment: Qty.: 0.0437 f(s)/Unit Total : 0.2621 f(s) 303 stainless steel round bar .750" Material: (M303R0750) Batch: M102077			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: 1-TURN AS PER FOLIO FA723 & DWG D3663 FOLIO REV: No Folio DWG REV: A			
2-DEBURR AS REQUIRED			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE.			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 115			

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Drawing Name: BUSHING

Job Number: 37397

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



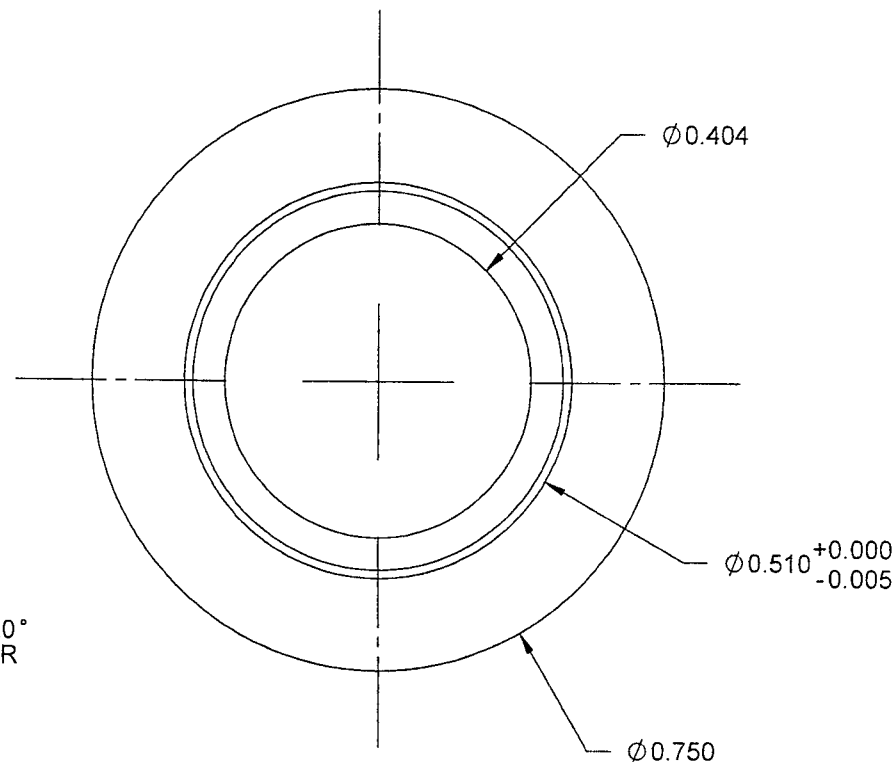
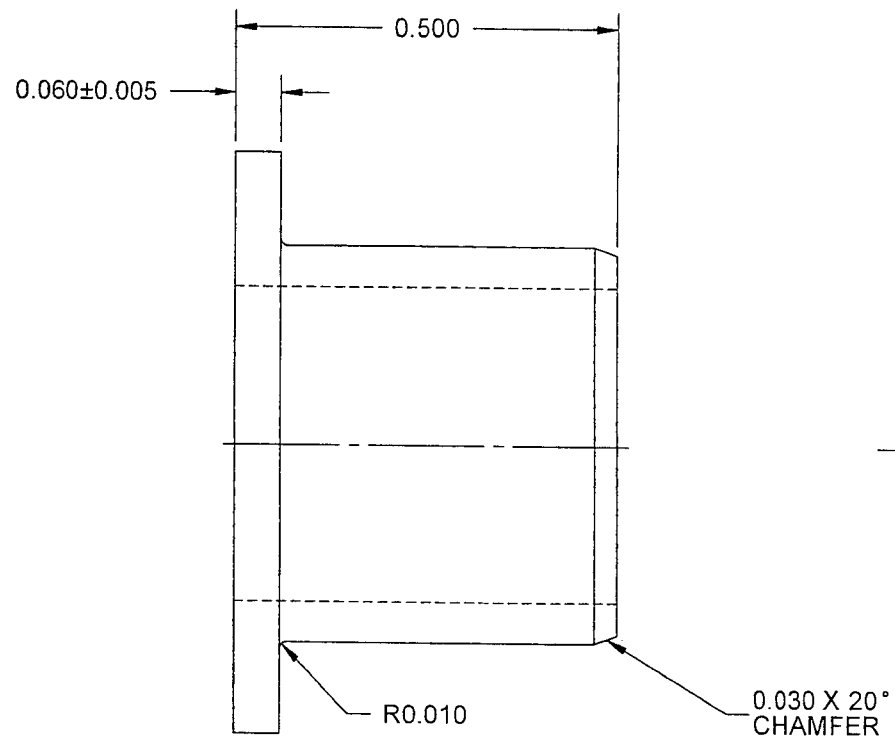
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



in 2008/2/19 (20)

W



D3663-1 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303RX.XXX)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02

1635E
9/21

RELEASED
07.11.22

A	NEW ISSUE	PH	07.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	EH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	EH		
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	DA	D3663	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.	W	BUSHING	4:1
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

15193

Certificado Tipo: EN 10.204/3.1

Certificate Type:

Certificat Type:

Datum - Fecha - Date 13 DE MARZO 20 06

Prüf-nr.-Certificado-Certificate-Certificat 532.326

Rechnung-Factura-Invoice-Facture

Werte-Nr. N° de Matéria W/Comanda N°	Bestell-Nr. Pedido n° Your order N° W/Comanda N°	Anforderungen/Requisitos/Requirements/Condições SAR AMS 5640T-03.TYPE 1 QQ-S-764B-70 Amd.2 COND.A	Material Material Materiale Material	Material Material Materiale Material
321.981	060074-MAG		AISI-303	
			Einspeicherung: Correspondence: According to: D'accord avec: Ausgabe-Edition-Edition:	
			ASTM A 582/A582M-05	

Prüfgegenstand-Profil de prueba-Item inspected-Profil essayé: Stabstahl-Barras de acero-Steel bars-Barras d'acier:

Kenzeln-Distinctive-Distinctif-Identif.

Erweiterung:
Forme de l'acier:
Métallurgie:
Procédé d'élaboration:G - Argon Gaseous Penetration
E - A. G. D.

Umfang der Lieferung Objeto del suministro Scope of delivery Objet de la livraison	Pos. Nr. Pos N° Sample N° Echantillon N°	Bündel Bultos Bundles Dalle	Stärke Barras Bars Barras	Gewicht Peso Kg. Weight Poids	Geometrie - Designación Shape and size - Profil et dimension	Probe N° Prueba N° Sample N° Echantillon N°	Schmelze - Oñale Heat - Coûle
		3		4.868LBS	ROUND 3/4"	1	904441

Zeichnen des Lieferwerkes - Anzeigen des Lieferanten:
Trade mark - Signe du fournisseur:Verteilen/Inspector stamp - Anzeigen des Lieferanten:
Vider-Inspector stamp - Signe de l'export

Geprüft Lanzado Pulido Lanzado	Geprüft Revisado Revisado	Vergleichen Comparado Hard/Temp. Talla	Normalisieren Normalizado Normalized	Abgeschreckt Fierterpelo Quench Fierterpelo	Geprüft Decapado Pickled Decapado	Geprüft Toc. bento Rough tested Borrado	Drehen Tornado Turned Tornado	Geprüft Revisado Comparado Revisado	Puliert Pulido Polished Pulido	Geprüft Estimado Cold drawn Enfriado	ASTM-A 484-05
									X	X	

Wertebehandlung:
Valorización: Wmto:
Heat treatment:
Tratamiento térmico:

1.050 , 4 HORAS

Qual C/Water:
Grado C/Water:
Grado C/Water:
Grado C/Water:

Ergebnis der Prüfungen - Resultados de los ensayos - Test results - Résultats des essais

Abmessungen des Probekörpers. Medida de los Probetas. Dimensions of specimens. Dimension des échantillons.	Temp °C	Probe Nr. Pos N° Spec. N°	0.2% Re _{0.2} MPa	1% Re ₁ MPa	RM N/mm ² MPa	A % L ₁ min L ₂	Z %	Kerbtests - Resistencia ISO V 50 Impact Test - Resistance	Härte Dureza Hardness Dureté VH
			KSI		KSI				
	20C	1	81.216		102.536	34	55		223

Schmelzeanalyse - Análisis químico - Chemical analysis - Analyse Chimique

Schmelze Oñale Heat Coûle	C. %	Si. %	Mn. %	P. %	S. %	Cr. %	Mo. %	Ni. %	Ti. %	Cu. %	Co. %	N. %
904441	0,045	0,36	1,67	0,029	0,312	17,70	0,26	8,40		0,45	0,170	0,0450

Beschreibung und Auswertung:
Comprobación visual y medidas
Visual inspection and dimensional checks
Contrôle visuel et dimensionnel

In Ordnung-Efective-Satisfactory.

MRCAMAX-PLUS

Free from mercury contamination
No Weld Repair.ACEROS INOXIDABLES CIARRA, S.A.
Abt. WerkstoffprüfungRDV/EDP
Acc. EN 10204

ALFREDO MOLINA

CERTIFICATION MNG.

Der Werkstoffverständige
Controlador de Fábrica
Werkstoff-Inspector
Inspecteur D'usine